

# Work Order ID 84351

**\*84351\***

Page 1

May-10-12 11:25:42 AM

Item ID: D4306-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Rib  
 Start Date: 10/05/2012 Start Qty: 2 **\*1\*** Cust Item ID:  
 Required Date: 24/05/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4306	C

100 0.00  
**\*100\***  
 Large Fab  
 Large Fab  
 Memo  
 1- Cut tube 50"  
 2- Bend tube with manuel pipe bender as per DT9567  
 \*\*\* Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*  
 3- Trim access tube material to finish size as per dwg D4306

110 QC6- Inspect dimensions to drawing 0.00  
**\*110\***  
 QC  
 Quality Control  
 Memo  
 0.00

2  
 (SA) 12-05-23  
 (2x) 12-05-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*84351\***

Page 2

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 10/05/2012      **Start Qty:** 1.00

**\* 1 \***

**Cust Item ID:**

**Required Date: 24/05/2012      Req'd Qty: 1.00**

**\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

**\*120\***

### Packaging

## Memo

0.00

## Packaging

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

## Memo

0.00

## Quality Control

 $2x$ 

12.05.24

12/5/2997

mf 12-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

May-10-12 11:25:45 AM

Page 1

Work Order ID: 84351

**\*84351\***

Parent Item: D4306-1

**\*D4306-1\***

Parent Item Name: Rib

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC  
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.750W.049

Purchased

No

100

f

445.4117

4.1666

4.385895

**\*M304TS0 750W 049\***

**\*\***

*SAD 12.05.23*

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT018

424.5255959

119147

2

119643

3.30639585

121439

419.2192

WA034

20.8861

121087

20.8861

*8.7718*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

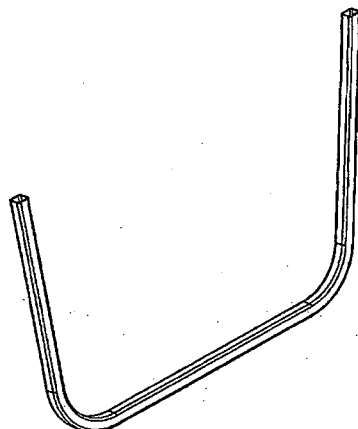
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

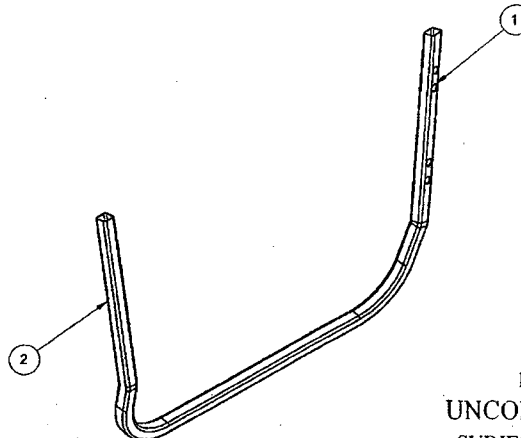
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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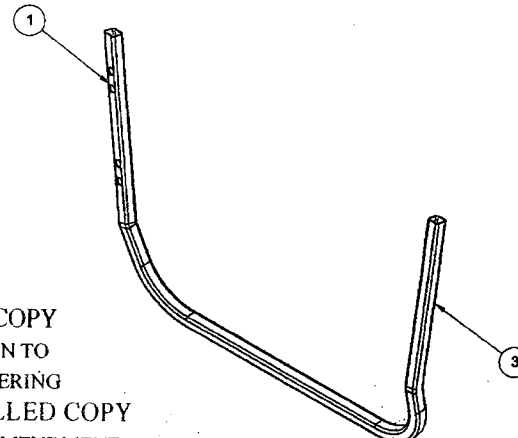
ITEM	QTY -043	QTY -044	QTY -045	P/N	DESCRIPTION
	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



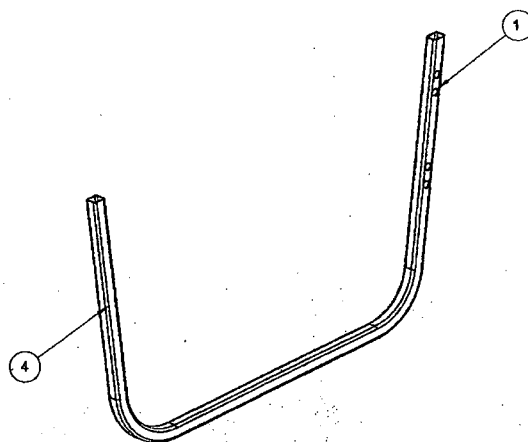
**D4306-1 RIB**



**D4306-043 RIB ASSY, LH**



**D4306-044 RIB ASSY, RH**







**D4306-045 RIB ASSY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 84351 MLJ

12/05/10

RELEASED  
2011-03-18

C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-4/-6); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.65" (C7-4, C8-4, C1-6, C2-6); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-6); ADDED 4.50" REF DIM ON D4306-043044 (B6-3, B3-5)	SC	11.02.09	
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17	
A	NEW ISSUE	CP	10.11.29	
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	SC			
CHECKED		DRAWING NO.	REV.	
MFG. APPR.		D4306	SHEET 1 OF	8
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

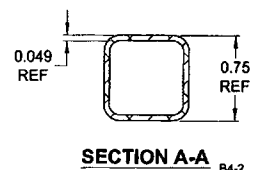
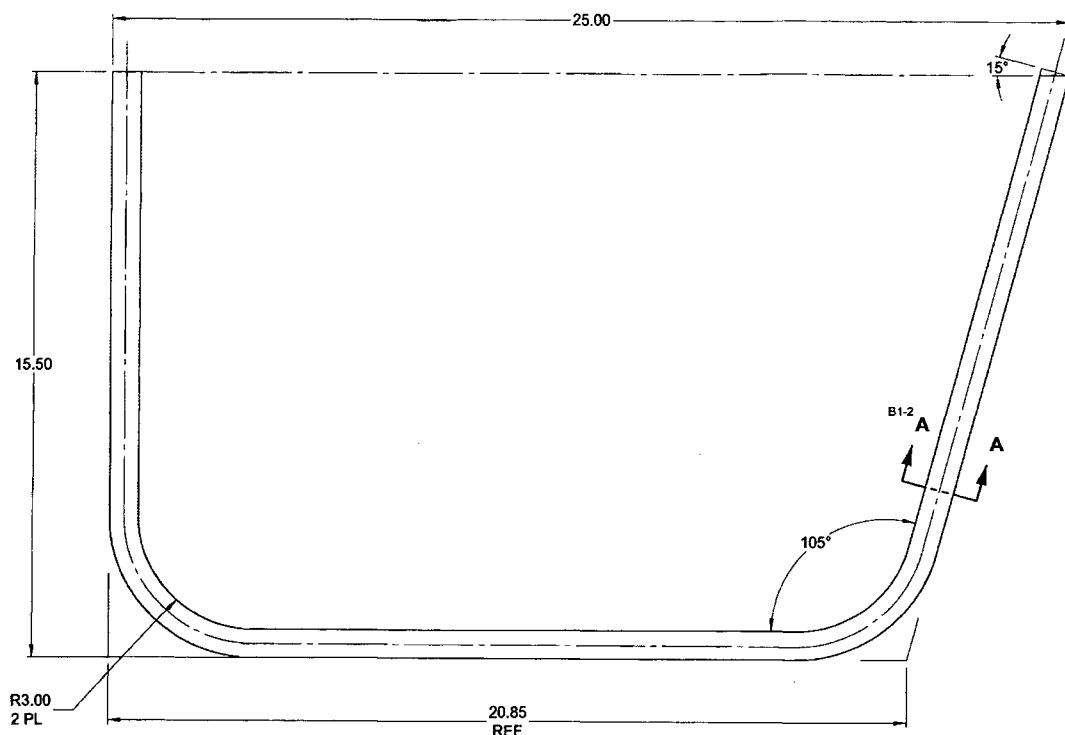
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



24351



8 D4306-1 RIB

RELEASED  
2011-02-24

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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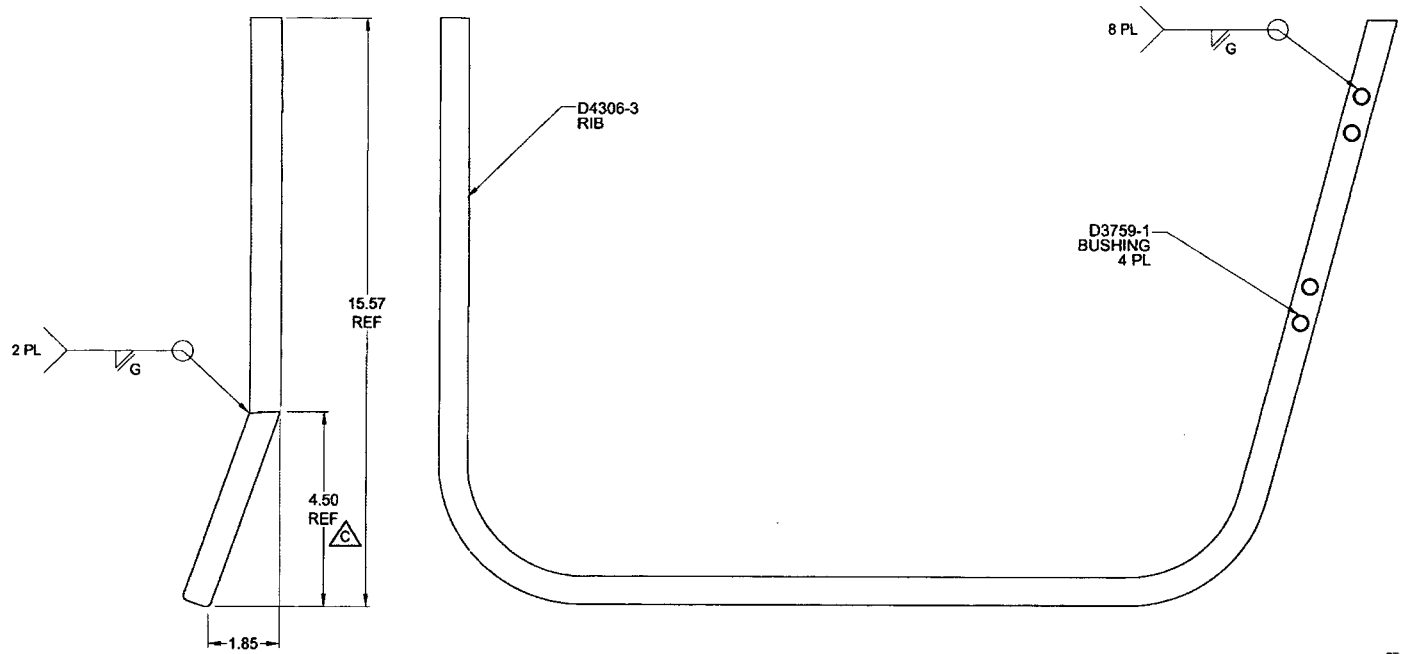
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

84357



**D4306-043 RIB ASSY, LH**

**RELEASED**  
2011-02-24  
ND

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	AS	TITLE <b>RIB</b>	SHEET 3 OF 8
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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

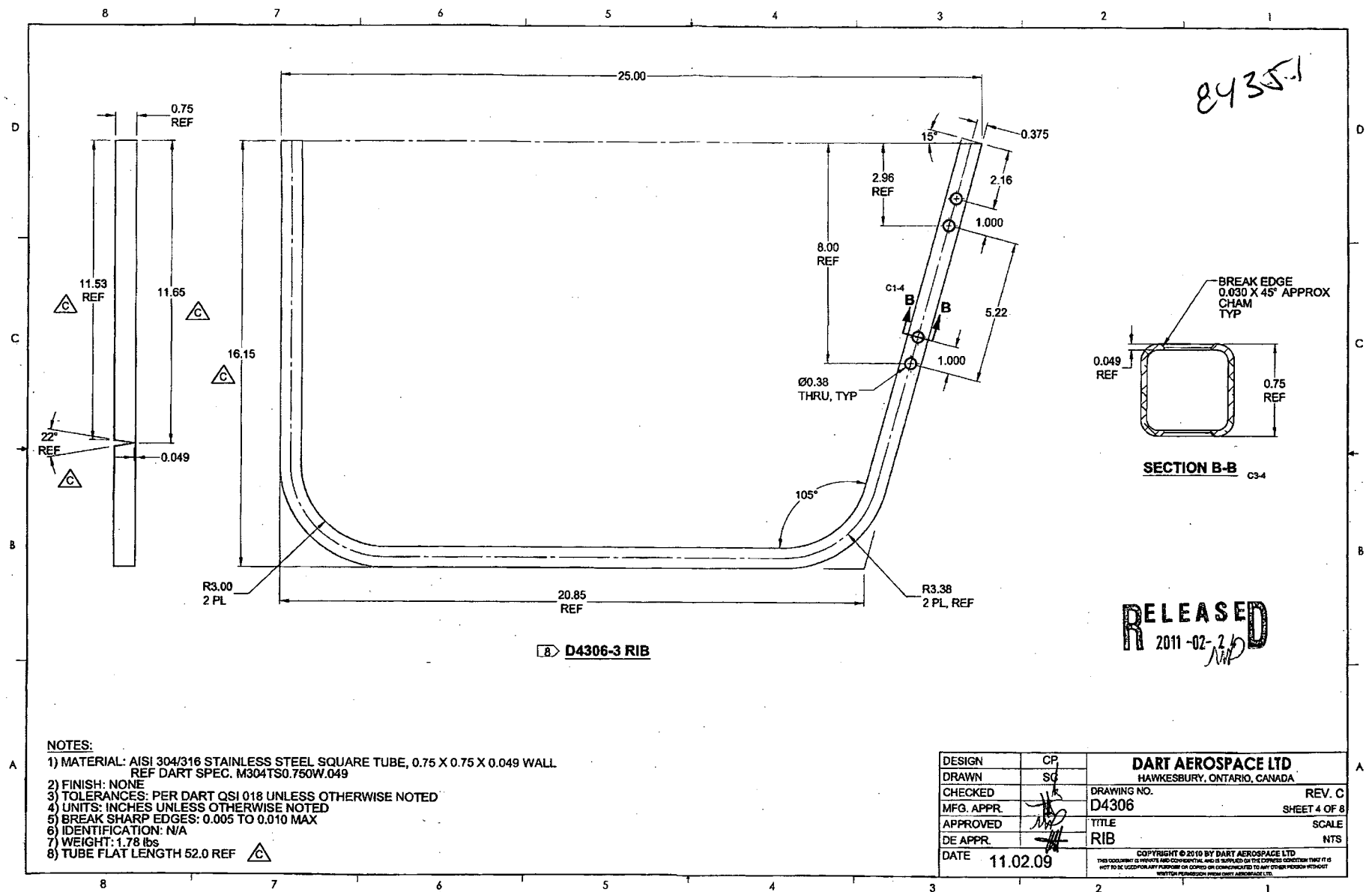
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8435-1



8 D4306-3 RIB

SECTION B-B C3-4

RELEASED  
2011-02-21

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL.  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 52.0 REF

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

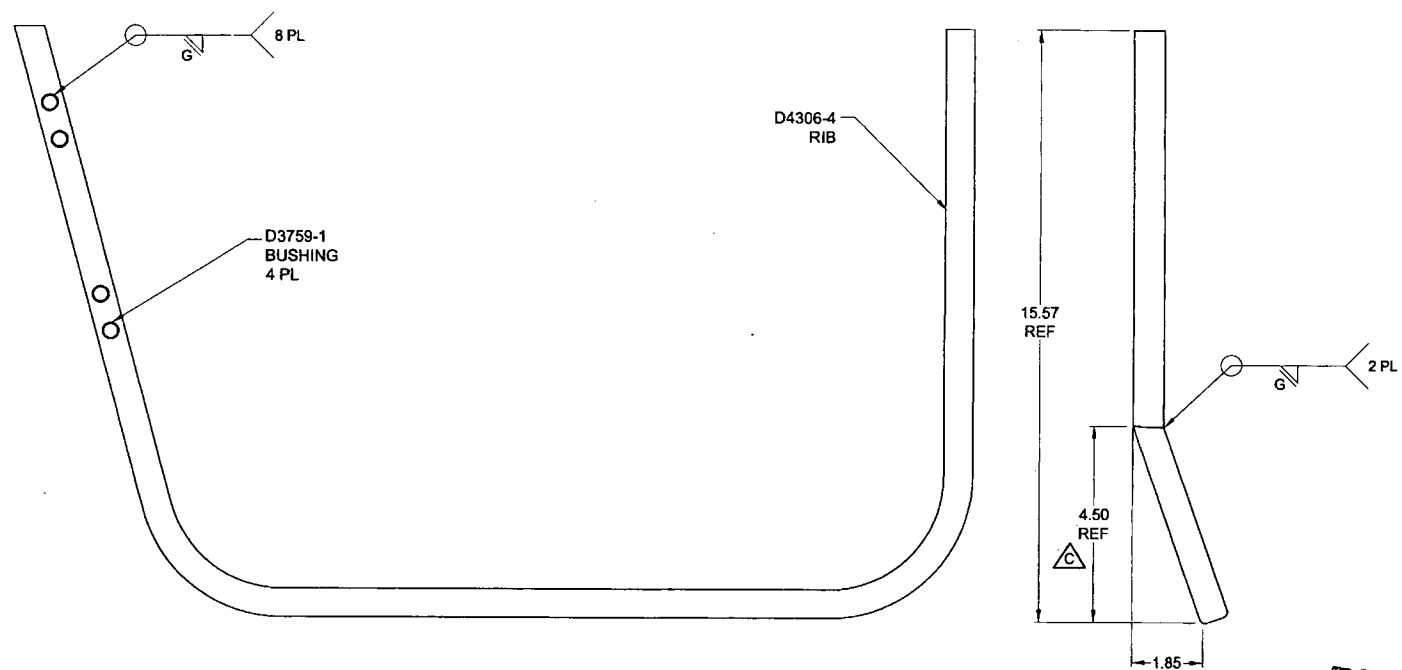
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8435.1



**D4306-044 RIB ASSY, RH**

**RELEASED**  
2011-02-24  
WJ

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

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MFG. APPR.	h	<b>D4306</b>	SHEET 5 OF 8
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W/O:		WORK ORDER CHANGES					
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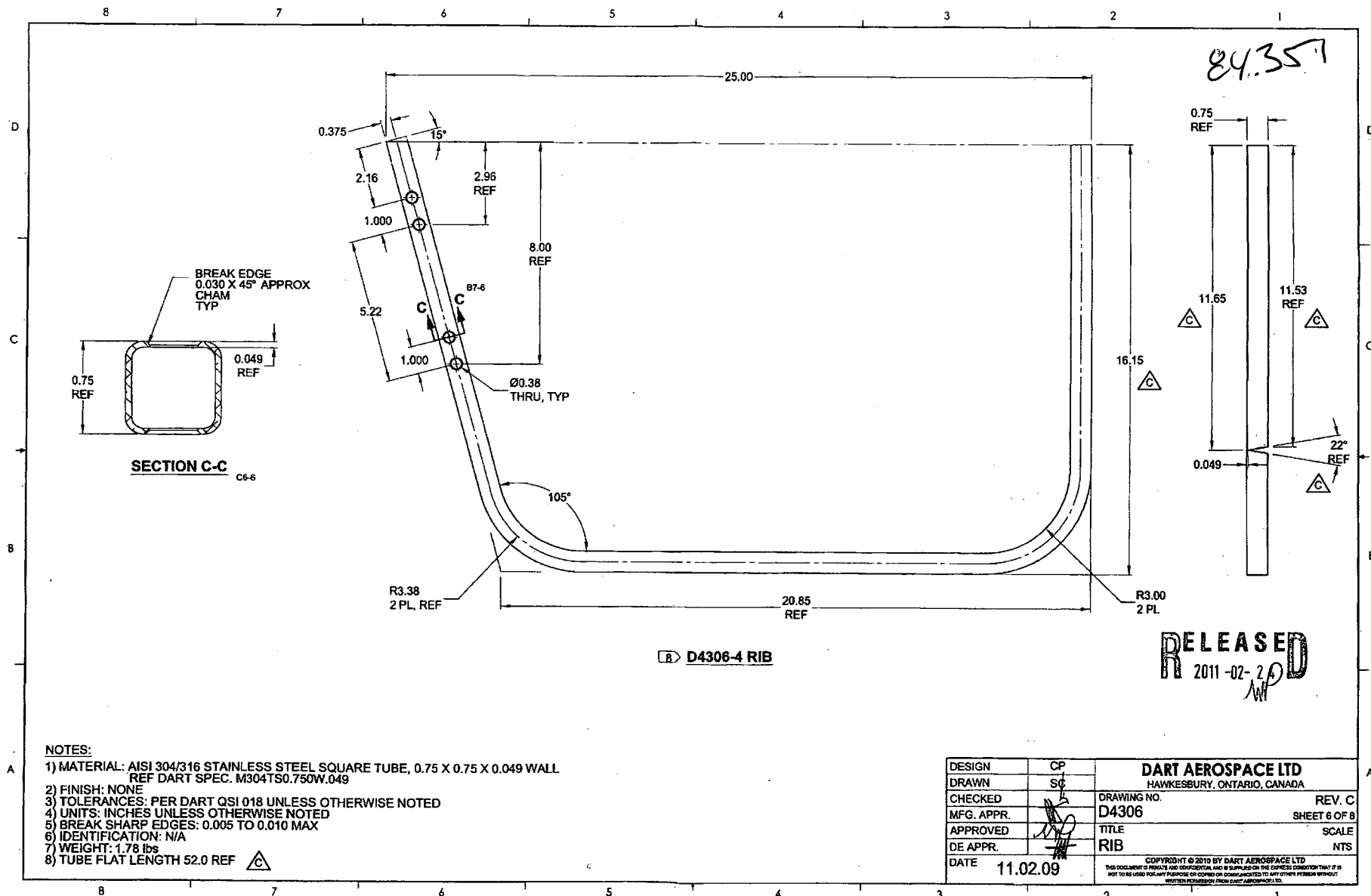
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**NOTE:** Date & initial all entries





W/O:		WORK ORDER CHANGES					
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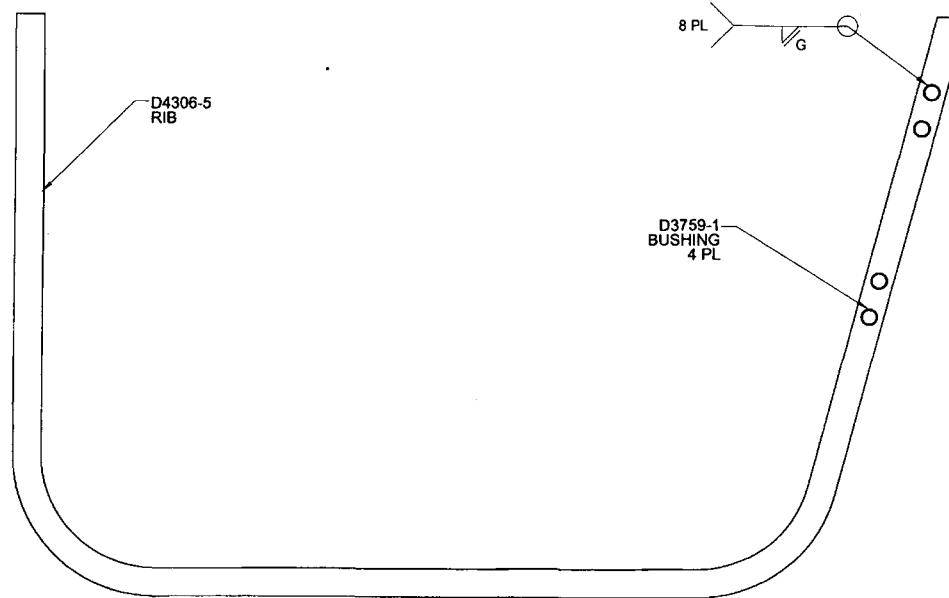
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

24357



**D4306-045 RIB ASSY**

**RELEASED**  
2011-02-24  
JMB

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO. <b>D4306</b>	REV. C
MFG. APPR.			SHEET 7 OF 8
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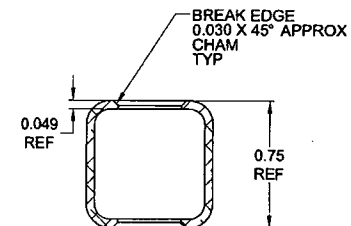
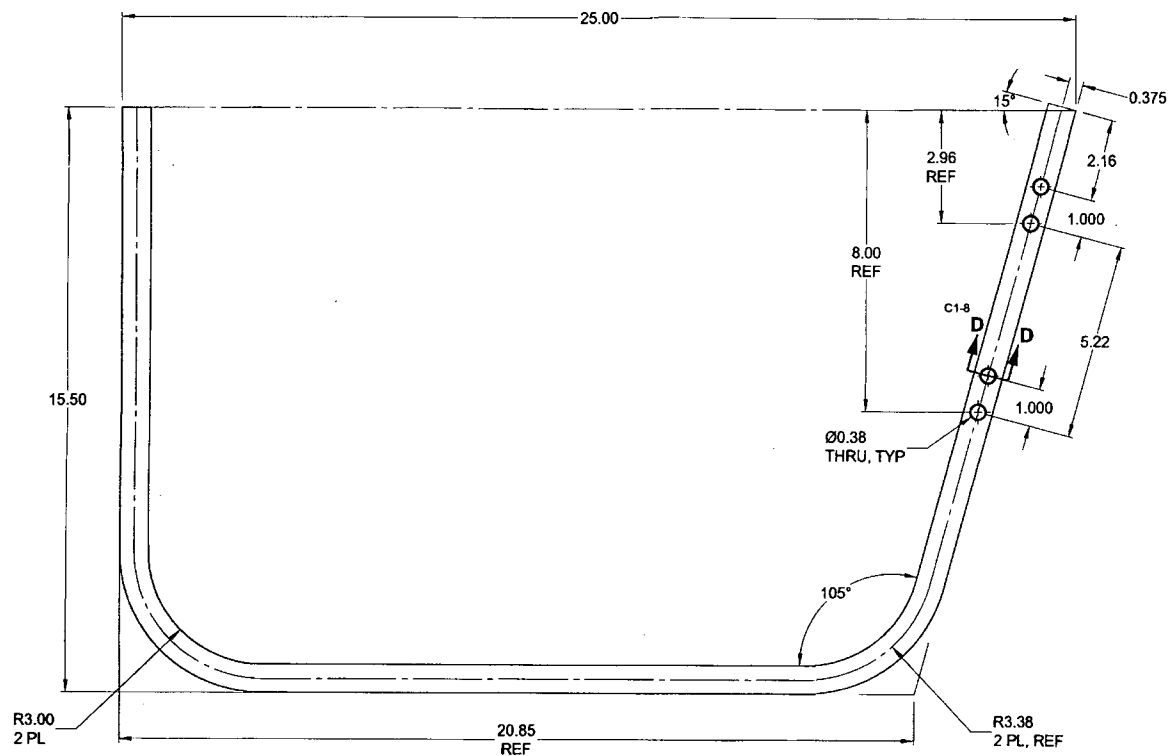
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



SECTION D-D  
C3-8

**D4306-5 RIB**

**RELEASED**  
2011-02-24

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	JS	DRAWING NO. <b>D4306</b>	REV. C
MFG. APPR.			SHEET 8 OF 8
APPROVED	MP	TITLE <b>RIB</b>	SCALE
DE APPR.			NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries